

Date: Monday, 11/6/2006 2:40:10 PM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : 206/OH-58 SADDLE, INBOARD, RIGHT SIDE
Job Number : 29347	
Estimate Number : 10940	
P.O. Number : N/A	Part Number : D29381
This Issue : 11/6/2006 S.O. No. : N/A	Drawing Number : D2938 REV B
Prsht Rev. : NC	Project Number : N/A
First Issue : N/A Type : MACHINED PARTS	Drawing Revision : B
Previous Run : 28862	Material : N/A
Written By : <u>SA 06/11/07</u>	Due Date : 11/26/2006 Qty: 10 Um: Each
Checked & Approved By : <u>SA 06/11/07</u>	
Comment : Est: B 06.06.26 New DWG rev (mpp 2069) EC	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	D6101003	7075-T7351 2X6.25X7.875
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 10.0000 Each(s)

Issue material from stock: 7075-T7351 (QQ-A-250/12)

Cut Size 2.0" x 6.25" X 7.88" Grain Along 7.88" Length

(D6101-003)

Batch No: B25346

SA 06/11/07

16

2.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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Comment: HAAS CNC VERTICAL MACHINING #1

Program part number and batch number. —

1-Inspect part number and batch number are programmed correctly.

2-Machine Step No 1 of Folio and visually inspect as per dwg D2938 & attached Dimension Sheet

3-Machine Step No 2 of Folio and visually inspect as per dwg D2938 & attached Dimension Sheet

4-Machine Step No 3 of Folio and visually inspect as per dwg D2938 & attached Dimension Sheet

5-Deburr

SA 13.1 06/11/07

16

3.0	MILLING CONV.	CONVENTIONAL MILLING MACHINE
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Comment: CONVENTIONAL MILLING MACHINE

Machine Keyway and inspect per attached dimension sheet

SA 06.11.07

16

4.0	QC1	INSPECT ALL DIM TO DIM SHEET
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Comment: INSPECT ALL DIM TO DIM SHEET

SA 13.1 06/11/07

16

5.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

SA 06/11/07

16

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: 17 Date: 06/12/12
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 11/6/2006 2:40:11 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206/OH-58 SADDLE, INBOARD, RIGHT SIDE

Job Number: 29347

Part Number: D29381

Job Number:



Seq. #:

Machine Or Operation:

Description:

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

a.m 06/11/30 (10x)

7.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

a.m/mh 06/12/11 (10x)

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

LB 06/12/11 (10)

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: *ST 476*

LB 06/12/11 (10)

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

LB 06/12/12 (10)

Job Completion



U DART

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	29347
Description: 206 Saddle, Outboard, Left side	Part Number:	D2938-1
Inspection Dwg: D2938 Rev. B		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2938 Rev. B and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	0.100	0.140		0.133	.130	.129	.130		
B	0.100	0.140		0.135	.130	.131	.130		
C	0.100	0.140		0.120	.130	.128	.129		
D	0.210	0.230		0.221	.219	.220	.220		
E	1.245	1.255		1.250	.250	1.250	1.250		
F	1.245	1.255		1.250	1.250	1.250	1.250		
G	2.495	2.505		2.500	2.500	2.500	2.500		
H	0.510	0.515		.514	.514	.514	.514		
I	1.572	1.582		1.577	1.577	1.576	1.577		
J	2.495	2.505		2.500	2.499	2.500	2.500		
K	0.257	0.262	DT8683	0.258	.258	.258	.258		
L	0.312	0.317	DT8686	0.316	.316	.316	.316		
M	0.235	0.240		.237	.237	.237	.237		
N	0.100	0.140		0.119	.119	.120	.119		
O	0.540	0.560		0.546	.550	.550	.550		
P	0.490	0.510		0.500	.499	.500	.499		
Q	3.715	3.725		3.719	3.719	3.719	3.720		
R	2.720	2.760		2.741	2.741	2.741	2.741		
S	0.240	0.270		0.251	.248	.250	.250		
T	0.100	0.180		0.139	.140	.140	.140		
U	1.625	1.635		1.629	1.630	1.630	1.629		
V	1.362	1.372		1.366	1.367	1.367	1.367		
W	0.316	0.321	DT8690	0.320	.320	.320	.320		
X	1.250	1.270		1.257	1.256	1.260	1.259		
Y	1.565	1.585		1.573	1.571	1.570	1.572		
Z									
AA									
AB									
AC									
AD									
AE									
AF									
AG									
AH									
Accept/Reject									

Measured by:	gnd / S.L.
Date:	06/11/11 / 06/11/12

Audited by:	En
Date:	06/11/12

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.12.12	Reformat; Added Dim. X-Y, DT8683, DT8686, DT8690	KJ/RF	

DART AEROSPACE LTD	Work Order:	29347
Description: 206 Saddle, Outboard, Left side	Part Number:	D2938-1
Inspection Dwg: D2938 Rev. B		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2938 Rev. B and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	0.100	0.140		.130	.122	.120	.124		
B	0.100	0.140		.131	.123	.120	.122		
C	0.100	0.140		.131	.123	.117	.119		
D	0.210	0.230		.220	.216	.216	.220		
E	1.245	1.255		1.250	1.249	1.250	1.250		
F	1.245	1.255		1.249	1.250	1.250	1.250		
G	2.495	2.505		2.500	2.499	2.500	2.500		
H	0.510	0.515		.514	.514	.514	.514		
I	1.572	1.582		1.576	1.577	1.577	1.576		
J	2.495	2.505		2.499	2.500	2.500	2.499		
K	0.257	0.262	-DT8683	.258	.258	.258	.258		
L	0.312	0.317	-DT8686	.316	.316	.316	.316		
M	0.235	0.240		.237	.237	.237	.237		
N	0.100	0.140		.119	.115	.113	.114		
O	0.540	0.560		.549	.551	.550	.550		
P	0.490	0.510		.500	.498	.500	.500		
Q	3.715	3.725		3.720	3.719	3.720	3.720		
R	2.720	2.760		2.741	2.741	2.741	2.741		
S	0.240	0.270		.250	.243	.245	.251		
T	0.100	0.180		.140	.140	.140	.140		
U	1.625	1.635		1.630	1.630	1.630	1.630		
V	1.362	1.372		1.366	1.367	1.367	1.367		
W	0.316	0.321	DT8690	.320	.320	.320	.320		
X	1.250	1.270		1.259	1.262	1.259	1.263		
Y	1.565	1.585		1.572	1.576	1.570	1.575		
Z									
AA									
AB									
AC									
AD									
AE									
AF									
AG									
AH									
Accept/Reject									

Measured by:	S.L.
Date:	06/11/12

Audited by:	En
Date:	06/11/12

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.12.12	Reformat; Added Dim. X-Y, DT8683, DT8686, DT8690	KJ/RF	

DART AEROSPACE LTD	Work Order:	29347
Description: 206 Saddle, Outboard, Left side	Part Number:	D2938-1
Inspection Dwg: D2938 Rev. B		Page 1 of 1

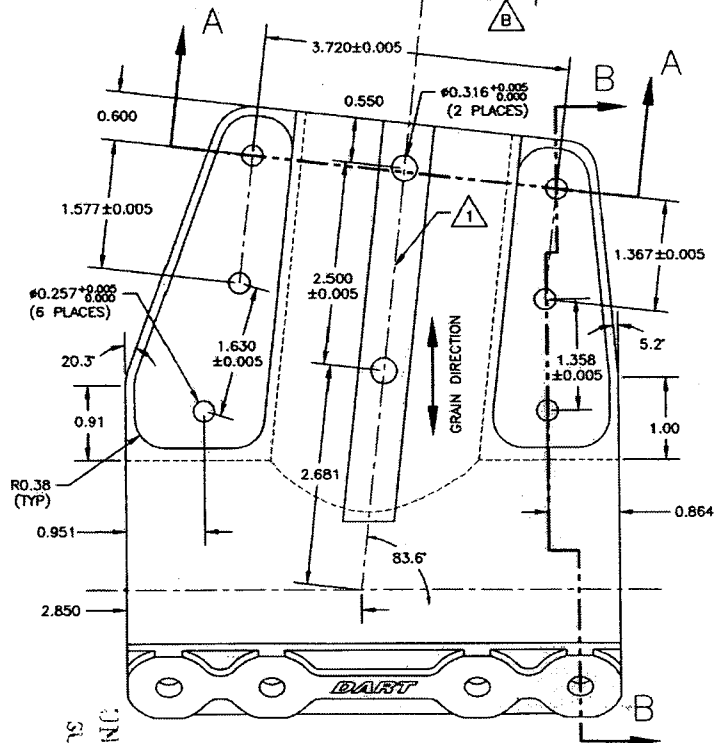
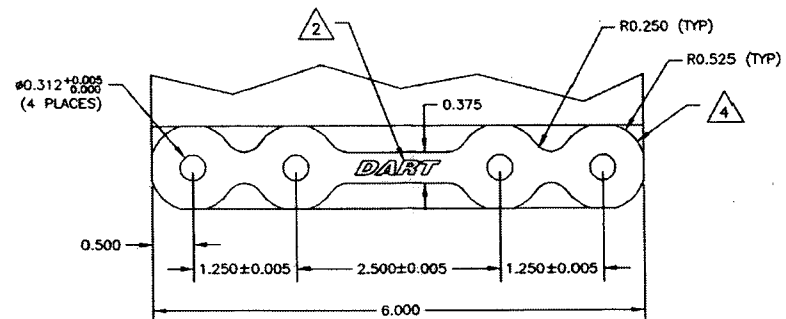
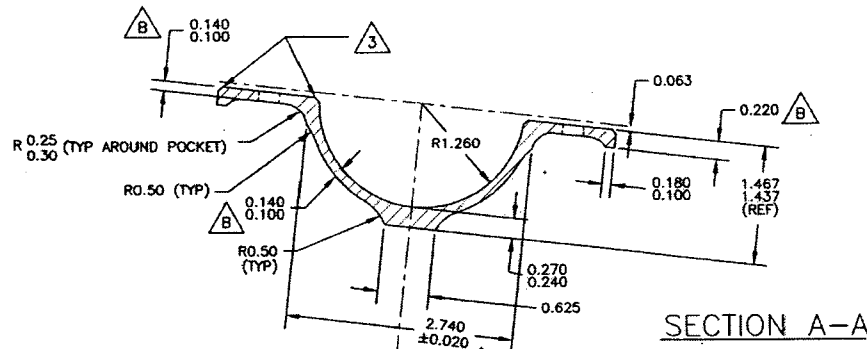
Inspect dimensions highlighted on inspection sheet drawing D2938 Rev. B and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	0.100	0.140		.121	.124				
B	0.100	0.140		.122	.123				
C	0.100	0.140		.114	.123				
D	0.210	0.230		.221	.221				
E	1.245	1.255		1.250	1.249				
F	1.245	1.255		1.250	1.250				
G	2.495	2.505		2.500	2.499				
H	0.510	0.515		.574	.574				
I	1.572	1.582		1.577	1.576				
J	2.495	2.505		2.500	2.499				
K	0.257	0.262	DT8683	.258	.258				
L	0.312	0.317	DT8686	.316	.316				
M	0.235	0.240		.235	.237				
N	0.100	0.140		.122	.122				
O	0.540	0.560		.550	.549				
P	0.490	0.510		.500	.500				
Q	3.715	3.725		3.719	3.719				
R	2.720	2.760		2.741	2.741				
S	0.240	0.270		.243	.251				
T	0.100	0.180		.140	.140				
U	1.625	1.635		1.629	1.630				
V	1.362	1.372		1.367	1.367				
W	0.316	0.321	DT8690	.320	.320				
X	1.250	1.270		1.269	1.261				
Y	1.565	1.585		1.581	1.573				
Z									
AA									
AB									
AC									
AD									
AE									
AF									
AG									
AH									
Accept/Reject									

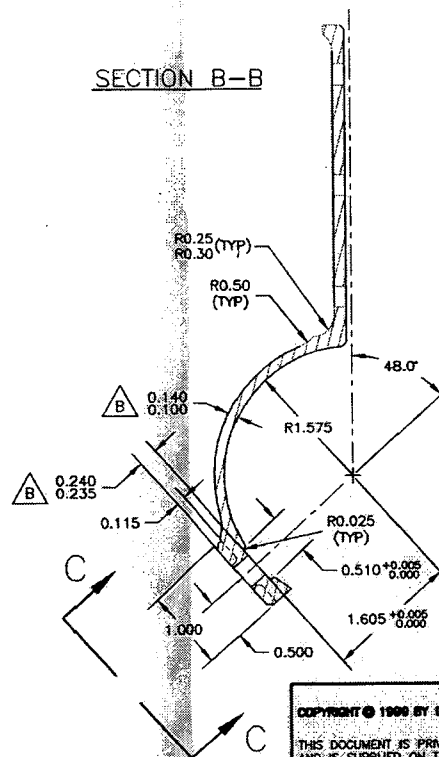
Measured by:	SL
Date:	06/11/12

Audited by:	En
Date:	06/11/12

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.12.12	Reformat; Added Dim. X-Y, DT8683, DT8686, DT8690	KJ/RF	



SECTION B-B



D2938-1 LH SADDLE (SHOWN)
D2938-2 RH SADDLE (OPPOSITE)

MATERIAL: 7075-T7351 (QQ-A-250/12)
 FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
 POWDER COAT GLOSS WHITE (REF 4.3.5.1) PER DART QSI 005 4.3
 BREAK ALL SHARP EDGES 0.010 TO 0.020
 TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.

- 1 ENGRAVE PART AND BATCH NUMBER IN THIS AREA 0.010 TO 0.015 DEEP
- 2 ENGRAVE DART LOGO TO MAX DEPTH OF 0.005 WITH MIN RAD 0.250
- 3 CHAMFER 0.050" x 45° AROUND THIS SURFACE (TYPICAL 2 PLACES)
- 4 CHAMFER 0.050" x 45°

RELEASED
 00-05-31

B	00.05.29	CHANGED GEOMETRY AND MATERIAL
A	99.11.12	NEW ISSUE
DESIGN	DRAWN BY	DART DART AEROSPACE USA, INC. BELLEVUE, WA
CHECKED	APPROVED	DRAWING NO. D2938
DATE	00.05.29	TITLE SADDLE OUTSIDE
		REV. B SHEET 1 OF 1 SCALE 2:3

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WORK ORDER NO. 29347
 UNCONTROLLED COPY
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 SHOP COPY
 RETURN TO
 ENGINEERING



Date: Tuesday, 10/3/2006 3:47:58 PM
User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : 206/OH-58 SADDLE, INBOARD, RIGHT SIDE
Job Number : 28862	
Estimate Number : 10940	
P.O. Number : N/A	Part Number : D29381
This Issue : 10/3/2006 S.O. No. : N/A	Drawing Number : D2938 REV B
Prsht Rev. : NC	Project Number : N/A
First Issue : N/A Type : MACHINED PARTS	Drawing Revision : B
Previous Run : 27117	Material : N/A
Written By : <u> </u>	Due Date : 10/30/2006 Qty: 8 Um: Each
Checked & Approved By : <u> </u>	
Comment : Est: B 00.06.26 New DWG rev (mpp 2069) EC	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	D6101003	7075-T7351 2X6.25X7.875
-----	----------	-------------------------



Comment: Qty.: 1.0000 Each(s)/Unit Total: 8.0000 Each(s)

Issue material from stock: 7075-T7351 (QQ-A-250/12)

Cut Size 2.0" x 6.25" X 7.88" Grain Along 7.88" Length

(D6101-003)

Batch No: B23347

2.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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Comment: HAAS CNC VERTICAL MACHINING #1

Program part number and batch number.

1-Inspect part number and batch number are programmed correctly.

2-Machine Step No 1 of Folio and visually inspect as per dwg D2938 & attached Dimension Sheet

3-Machine Step No 2 of Folio and visually inspect as per dwg D2938 & attached Dimension Sheet

4-Machine Step No 3 of Folio and visually inspect as per dwg D2938 & attached Dimension Sheet

5-Deburr

J.L 06/10/15

3.0	MILLING CONV.	CONVENTIONAL MILLING MACHINE
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Comment: CONVENTIONAL MILLING MACHINE

Machine Keyway and inspect per attached dimension sheet

J.L 06/10/15

4.0	QC1	INSPECT ALL DIM TO DIM SHEET
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Comment: INSPECT ALL DIM TO DIM SHEET

J.L 06/10/15

5.0	QC8	SECOND CHECK
-----	-----	--------------



Comment: SECOND CHECK

Sm 06/10/15

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: DP Date: 26/10/23
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 10/3/2006 3:47:58 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206/OH-58 SADDLE, INBOARD, RIGHT SIDE

Job Number: 28862

Part Number: D29381

Job Number:



Seq. #: Machine Or Operation: Description :

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

Y

06/10/18 x8

7.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

FL 06 10 18 (8)

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

RS 06/10/23 (8)

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

S/350

RS 06/10/23 (8)

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

RS 06/10/23 (8)

Job Completion



C 06/10/23

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order: 28862
Description: 206 Saddle, Outboard, Left side	Part Number: D2938-1
Inspection Dwg: D2938 Rev. B	Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2938 Rev. B and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	0.100	0.140		.123	.123	.123	.123		
B	0.100	0.140		.123	.123	.123	.122		
C	0.100	0.140		.120	.119	.119	.120		
D	0.210	0.230		.220	.220	.220	.219		
E	1.245	1.255		1.250	1.250	1.250	1.250		
F	1.245	1.255		1.250	1.250	1.249	1.250		
G	2.495	2.505		2.499	2.500	2.499	2.499		
H	0.510	0.515		.514	.514	.514	.514		
I	1.572	1.582		1.577	1.577	1.577	1.577		
J	2.495	2.505		2.500	2.500	2.499	2.500		
K	0.257	0.262	DT8683	.258	.258	.258	.258		
L	0.312	0.317	DT8686	.313	.313	.313	.313		
M	0.235	0.240		.238	.238	.237	.238		
N	0.100	0.140		.119	.118	.119	.119		
O	0.540	0.560		.551	.551	.550	.551		
P	0.490	0.510		.499	.498	.499	.500		
Q	3.715	3.725		3.720	3.720	3.720	3.719		
R	2.720	2.760		2.745	2.745	2.745	2.745		
S	0.240	0.270		.252	.252	.250	.249		
T	0.100	0.180		.140	.140	.140	.140		
U	1.625	1.635		1.630	1.629	1.630	1.630		
V	1.362	1.372		1.367	1.367	1.366	1.367		
W	0.316	0.321	DT8690	.318	.318	.318	.318		
X	1.250	1.270		1.260	1.258	1.259	1.258		
Y	1.565	1.585		1.572	1.569	1.569	1.569		
Z									
AA									
AB									
AC									
AD									
AE									
AF									
AG									
AH									
Accept/Reject									

Measured by:	J.L.
Date:	06/10/14

Audited by:	Er
Date:	06/10/15

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.12.12	Reformat; Added Dim. X-Y, DT8683, DT8686, DT8690	KJ/RF	#

DART AEROSPACE LTD	Work Order: 28862
Description: 206 Saddle, Outboard, Left side	Part Number: D2938-1
Inspection Dwg: D2938 Rev. B	Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2938 Rev. B and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	0.100	0.140		.122	.123	.123	.123		
B	0.100	0.140		.122	.123	.123	.124		
C	0.100	0.140		.118	.119	.118	.119		
D	0.210	0.230		.219	.220	.220	.220		
E	1.245	1.255		1.250	1.249	1.250	1.250		
F	1.245	1.255		1.250	1.250	1.250	1.250		
G	2.495	2.505		2.500	2.500	2.500	2.500		
H	0.510	0.515		.514	.514	.514	.514		
I	1.572	1.582		1.577	1.577	1.578	1.577		
J	2.495	2.505		2.500	2.500	2.500	2.500		
K	0.257	0.262	DT8683	.258	.258	.258	.258		
L	0.312	0.317	DT8686	.313	.313	.313	.313		
M	0.235	0.240		.238	.238	.238	.238		
N	0.100	0.140		.118	.119	.119	.118		
O	0.540	0.560		.551	.551	.551	.549		
P	0.490	0.510		.500	.500	.500	.500		
Q	3.715	3.725		3.721	3.720	3.721	3.720		
R	2.720	2.760		2.745	2.745	2.745	2.745		
S	0.240	0.270		.249	.249	.250	.251		
T	0.100	0.180		.140	.140	.140	.140		
U	1.625	1.635		1.630	1.630	1.630	1.630		
V	1.362	1.372		1.367	1.366	1.366	1.367		
W	0.316	0.321	DT8690	.318	.318	.318	.318		
X	1.250	1.270		1.260	1.260	1.260	1.258		
Y	1.565	1.585		1.572	1.573	1.573	1.571		
Z									
AA									
AB									
AC									
AD									
AE									
AF									
AG									
AH									
Accept/Reject									

Measured by:	JL
Date:	06/10/15

Audited by:	Er
Date:	06/10/15

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.12.12	Reformat; Added Dim. X-Y, DT8683, DT8686, DT8690	KJ/RF	

